

Work Order ID 162262***162262***

Page 1

Wednesday, May 31, 2017 9:27:02 AM

Item ID: D2282-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle Assembly
Start Date: 6/5/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 6/23/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: DA DAS 21 9-89 Date: 20170531 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2282	Rev E

100

0.00

100

Large Fab

Large Fab

Memo

2.00

Large Fab

1-Weld as per D2282-043 Saddle Assembly

A/RER316L SS

Filling Rod

Dwg Rev: E

110

0.00

110

Small Fab

Small Fab

Memo

0.39

Small Fab

1- Grind weld with rough pad and brown pad, take all welding marks out and
deburr holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***

120

0.00

120

QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.20

Quality Control

10 Q.L 17-08-0510 Q.L 17-06-05(10) 17.06.05 PD

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	1.00							
Quality Control									

17/6/17



JUN 05 2017

Pieclist Print

Wednesday, May 31, 2017 9:27:01 AM

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Work Order ID: 162262

162262

Parent Item: D2282-043

D2282-043

Parent Item Name: Saddle Assembly

Start Date: 6/5/2017

Required Date: 6/23/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2281		Manufactured	No			100	Each	55.0000	1	10			
D2281									**	Q.L		17-06-05	
Jack Saddle													

Location Loc Qty Loc Code

WA001 55

150910 0

160570 55

D2282-7		Manufactured	No			100	Each	95.0000	2	20			
D2282-7									**	Q.L		17-06-05	
Tube													

Location Loc Qty Loc Code

WA001 95

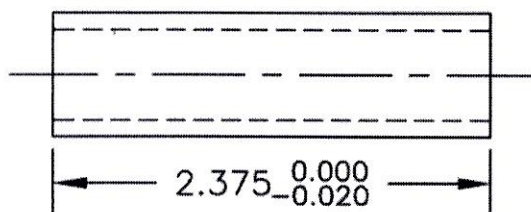
160573 95

20

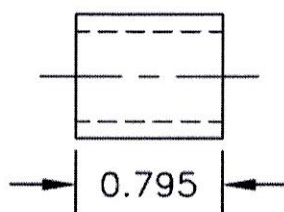


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

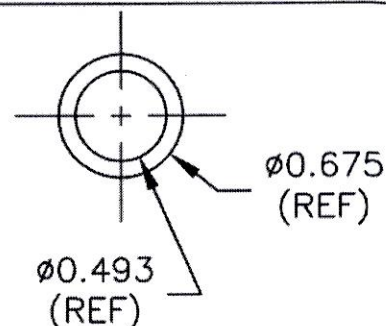
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05/09/16



D2282-3

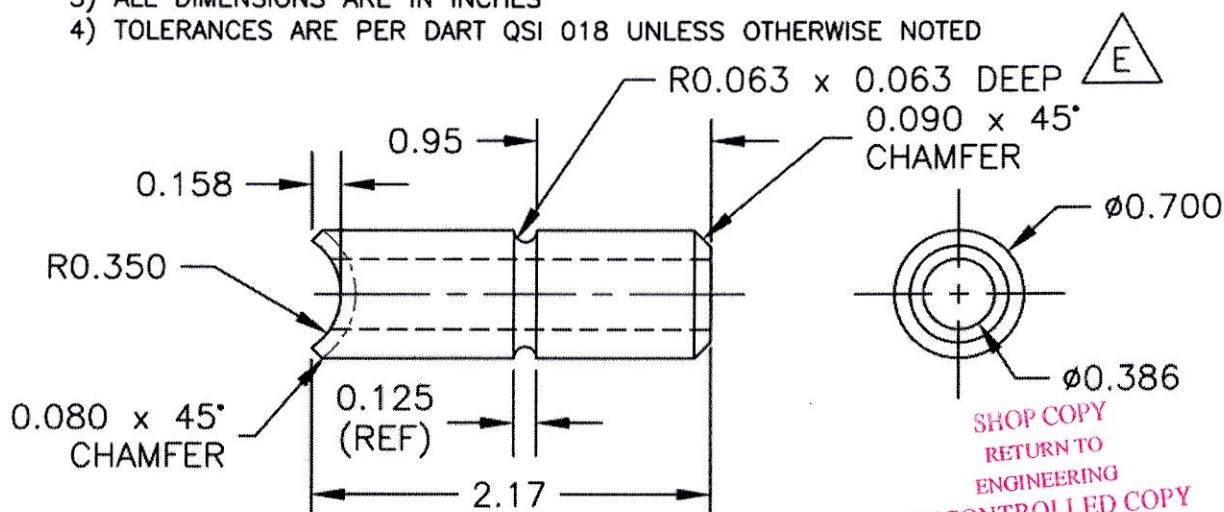


D2282-7



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162262

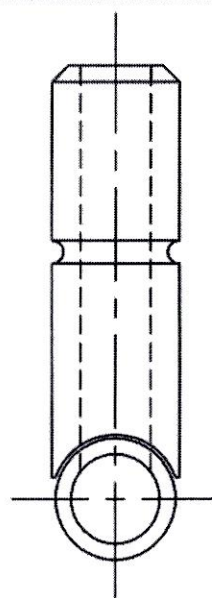
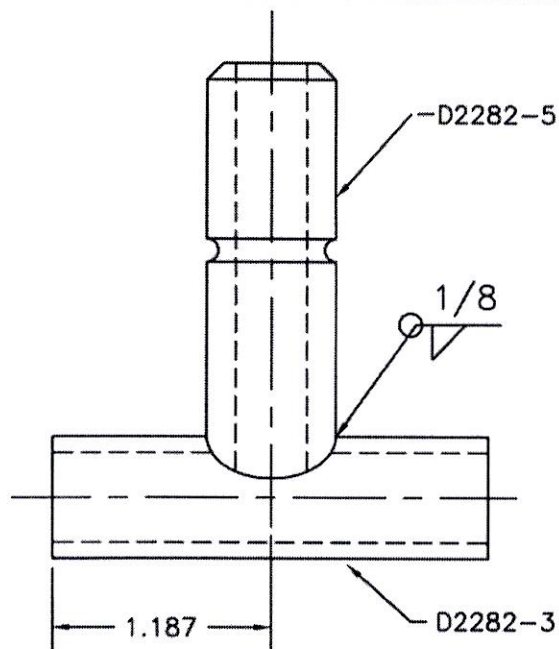


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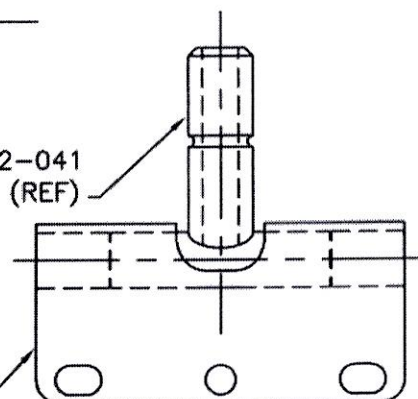


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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

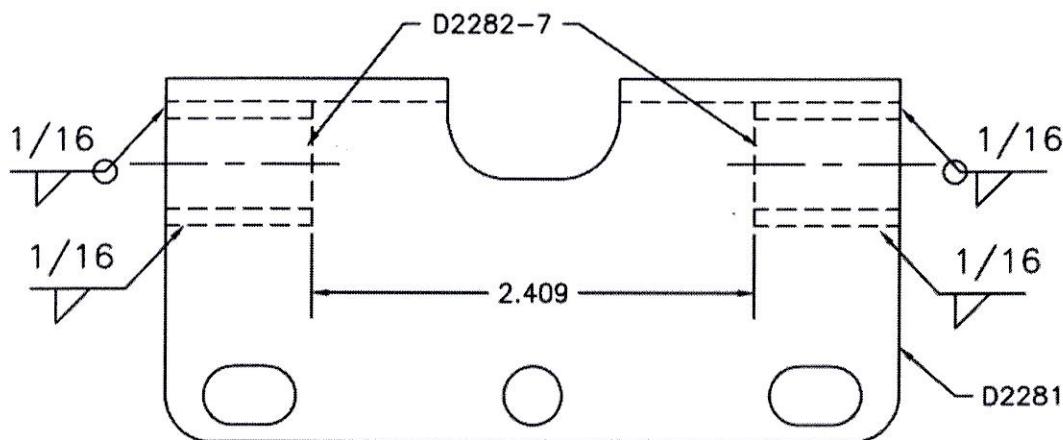


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05/09/16

D2282-041
(REF)



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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